

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 29564  
Estimate Number : 10849  
P.O. Number : *N/A*  
This Issue : 11/21/2006 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : LARGE FAB ASSY  
Previous Run : 27936  
Written By : \_\_\_\_\_  
Checked & Approved By : *KJ* 06 11 21  
Comment : Est Rev:D As Per Ecn 766 06-01-

Drawing Name	: 206 A/B STEP ASSEMBLY			
Part Number	: D206628011			
Drawing Number	: N/A			
Project Number	: N/A			
Drawing Revision	: N/A			
Material	: N/A			
Due Date	: 12/5/2006	Qty:	4	Um: Each

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-011 CHG 002

K-8 06-11-27

2.0	29564A	206B STEP ASSY, LH
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**Comment:** Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2721-041 B 29564A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment: PACKAGING RESOURCE #1**

## Pick Packing Kit

4.0	D27313	Mounting Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
-----	-------------	-------------

2 D2731-3 Mounting Lug

Batch

Batch  
B27420 8X ✓  
~~B27420 8X~~

5.0	D27317	Mounting Lug
-----	--------	--------------



**Comment:** Qty.: 2.0000 Each(s)/Unit      Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
-----	-------------	-------------

2. D2731-7 Mounting Lug

Batch

Batch  
B28936 ✓

Box 63/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:30:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 29564

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total: 4.6830 f(s)

Pick:

Qty	Part #	Description	Batch
2	D2856-400 6.9"	Abrasion Strip	B29850

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total: 2.1840 f(s)

Pick:

Qty	Part #	Description	Batch
2	D2856-400 6.25"	Abrasion Strip	B29850

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-041	LUG ASS'Y	B29994

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-043	LUG ASS'Y	B29166

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-15A	Bolt	M103585

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-11A	Bolt	M100743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LP Date: 07/04/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 11:30:13 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 29564

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

~~11788 (2)~~

M102929

~~X 110294~~

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M103338

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M103349

P 7/4/11

(4)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

P 7/4/11

(4)

C26710411 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-011

Location:

PPP Rev:

K

P 7/4/11 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

P 7/4/11

Job Completion



u 07.04.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

678-011

Date: Tuesday, 11/21/2006 11:30:33 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B STEP ASSY, LH
Job Number	: 29564A		
Estimate Number	: 11698	Part Number	: D2721041
P.O. Number	: N/A	Drawing Number	: D2721 REV C
This Issue	: 11/21/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: N/A Type : LARGE FAB ASSY	Material	: N/A
Previous Run	: 27936A	Due Date	: 12/5/2006 Qty: 4 Um: Each
Written By	: <u>JA 061121</u>		
Checked & Approved By	: <u>JA 061121</u>		
Comment	: Est Rev: F As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B29607

Check Material for any Dents or Defects

FF 07-02-28

4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-1 using D2622 extrusion as per Dwg D2721  
Deburr and bevel ends for welding

FF 07-02-28

4

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	322340

FF 07-03-01

4

4.0	D34611	PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	322311

FF 07-03-01

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 11/21/2006 11:30:34 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 29564A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3461-3 Plate 326312

*PE. 07.03.01*

4

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3461-5 Plate 326313

*PE. 07.03.01*

4

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3461-7 Plate B26314

*PE. 07.03.01*

4

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch:

M100237

~~M100237~~ M100225

Grind end cap welds flush

*PE. 07.03.01*

*PE. 07.03.03*

4

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*11/21/06/05 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 11:30:34 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 29564A

Part Number: D2721041

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/05 (4)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H

07/03/06 (4)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE. 07.03.10

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: M100237

Grind End Cap Welds Flush

FE. 07.03.10

FE. 07.03.10

FE. 07.03.10

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/12 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/12 (4)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

FD/a.m

07/03/12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LD Date: 07/04/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:30:34 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 29564A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a.m.* 07/03/13 (4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m.f.* 07/03/13 (4x)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

*FL/m.f.* 07/03/13 (4)

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07-03-13* (4)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07-03-19 Per labels*  
*PPP B29564*  
*7/4/11*

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/04/12* (4)

Job Completion



*U 07-04-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

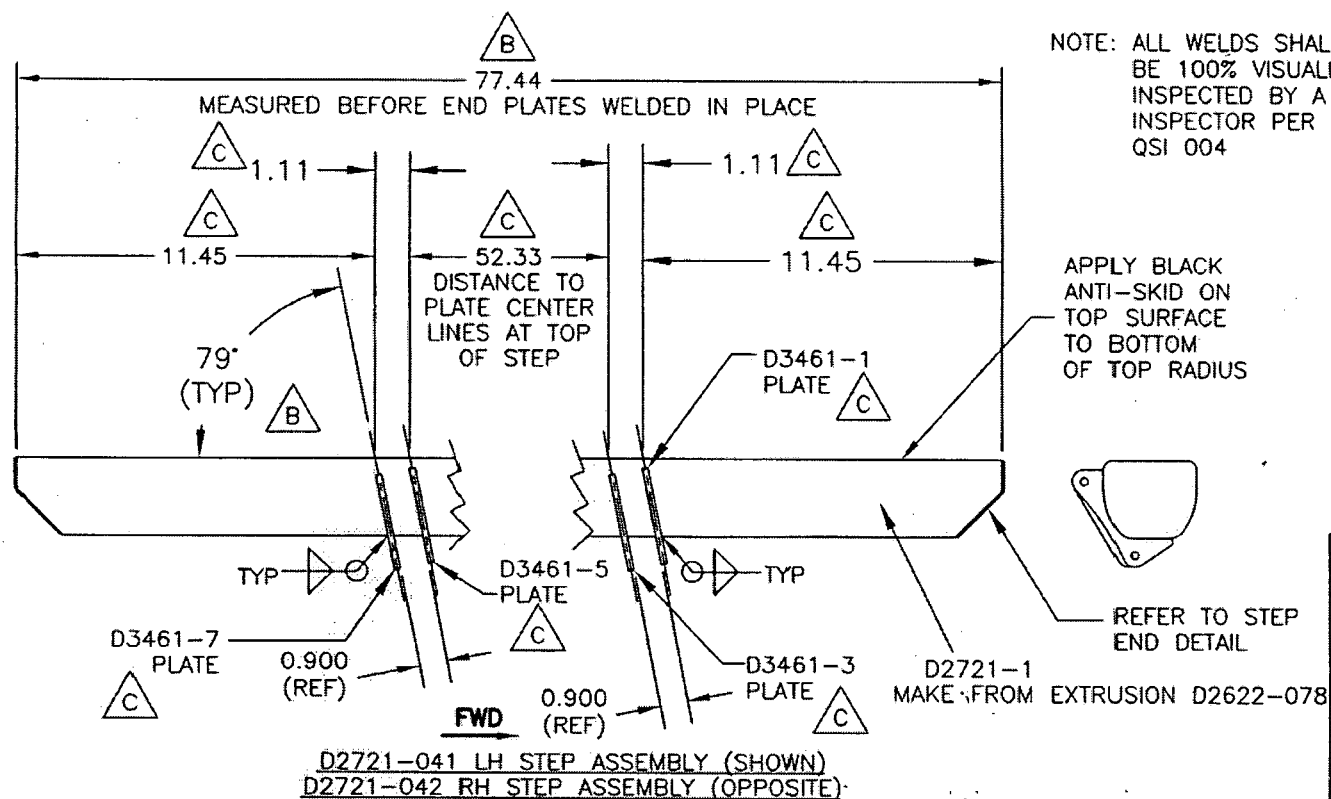
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
05-11-14 ~~JK~~

DESIGN	DRAWING BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	REV. C
CHECKED	APPROVED	DRAWING NO.	
<del>PH</del>	<del>PH</del>	D2721	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.19	1	206B STEP ASSEMBLY	NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0	
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7	



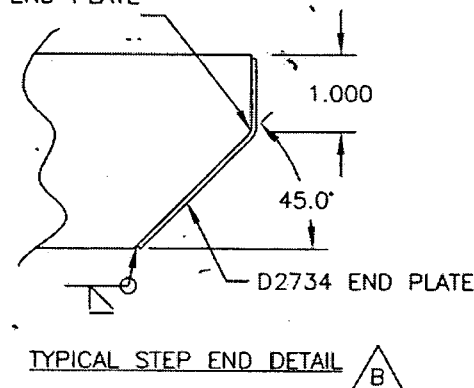
## D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTENSION
2	2	D2734	END PLATE
1	1	D3481-1	PLATE
1	1	D3481-3	PLATE
1	1	D3481-5	PLATE
1	1	D3481-7	PLATE

**D2721-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622  
2) WELD PER DART QSI 004  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
4) ALL DIMENSIONS ARE IN INCHES  
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29564A



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